

IN THE CLAIMS:

1. (Currently Amended) An aluminum alloy material billet as cast for forging, obtained by a continuous casting process, the alloy comprising: a surface of which roughness is not more than Ra 35, and a segregation layer having [[0.1]] 0.2 to 2 mm thickness and generated in the surface.

2. (Currently Amended) An aluminum alloy material billet as cast for forging according to claim 1, wherein Ca is added in a range from 0.005 to 0.015 wt %.

3. (Currently Amended) An aluminum alloy material billet as cast for forging according to claim 1, wherein Be is added in a range from 0.0005 to 0.020 wt %.

4. (Withdrawn-Currently Amended) A continuous casting process for an aluminum alloy billet as cast material in accordance with claim 1 for forging, the process comprising: charging a melted metal consisting of the aluminum alloy material into a mold at a predetermined casting rate, the mold having a discharge edge through which the solidified aluminum alloy material is discharged; and controlling the casting rate such that a solidification interface of the aluminum alloy material is positioned inside the mold away from the discharge edge.